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Date: Thursday, 8/23/2007 11:52:20 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : C-BOX OIL COOLER LINE SUPPORT
Job Number : 34231	
Estimate Number : 12477	
P.O. Number : N/A	Part Number : D412705019
This Issue : 8/23/2007 S.O. No. : N/A	Drawing Number : IIN D412-705 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 33584	Material : N/A
Written By : <u>                    </u>	Due Date : 9/20/2007 Qty: 4 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est Rev.D Removed Manufacturing 06-06-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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KS 07.09.05 (4)

Comment: Photocopy bluefile & type labels per PPPD412-705-019	CHG001
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6 7/12/03

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0	D3259041	Access Panel Assembly LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Access Panel Assembly LH (3)
Batch: 341240 35240 50

4.0	D3259042	Access Panel Assembly RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Access Panel Assembly RH (1)
Batch: 23263 3363 50 (341241) (2)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS
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6 7/12/03 (4)

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D412-705-019
Location: _____
PPP Rev: A

AS 07/12/03 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/12/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:20 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: C-BOX OIL COOLER LINE SUPPORT

Job Number: 34231

Part Number: D412705019

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

2 08/12/04

Job Completion



U 8/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-705-011 Twin Pak E-Z Access Kits (net)	6.3 lb 2.86 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	189 in 4.80 m	1190.7 in lb 13.73 m kg
D412-705-013 Intake Plenum Access Panel Kit	2.5 lb 1.16 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	175 in 4.44 m	437.5 in lb 5.15 m kg
D412-705-015 Drive Shaft Tunnel Modification Kit	1.1 lb 0.50 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	189 in 4.81 m	208.2 in lb 2.41 m kg
D412-705-017 N1 Gearbox Access Panel Kit (net)	1.0 lb 0.47 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	166 in 4.22 m	166.0 in lb 1.98 m kg
D412-705-019 C-Box Oil Cooler Line Support Access Kit (net)	1.2 lb 0.53 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	238 in 6.05 m	278.5 in lb 3.21 m kg
D412-705-021 Oil Pressure Transmitter Access Kit (net)	0.3 lb 0.14 kg	-6.0 in -0.15 m	-1.8 in lb -0.02 m kg	166 in 4.22 m	49.8 in lb 0.60 m kg
D412-705-023 Oil Cooler Support Removable Lower Panel Kit (net)	0.2 lb 0.09 kg	0.0 in 0.0 m	0.0 in lb 0.0 m kg	238 in 6.05 m	47.6 in lb 0.55 m kg

## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-041	ACCESS PANEL ASSEMBLY
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
		44	36		12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
		22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

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Date: 04.09.27

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